


Date: Tuesday, 3/11/2008 7:53:38 AM
User: Kim Johnston

Process Sheet

12

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : REMOVABLE HELI UTILITY STEP RH	
Job Number : 37725	Part Number : D205541048	
Estimate Number : 13195	Drawing Number : IIN D205-541 REV G	
P.O. Number :	Project Number :	
This Issue : 3/11/2008 S.O. No. :	Drawing Revision : G	
Prsht Rev. : NC	Material :	
First Issue : // Type : LARGE FAB ASSY	Due Date : 3/17/2008	Qty: 1 Um: Each
Previous Run : 37519		
Written By :		
Checked & Approved By : <u>AS 080311</u>		
Comment : Est Rev: A new issue 08-02-19 verified by: LL		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD205-541-048 CHG001

2.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

3.0 D3724042 Step Assy

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Step Assy 37974

4.0 D37311 PLATE

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
PLATE B37124

5.0 D3736041 PLATE ASSEMBLY

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
PLATE ASSEMBLY B37126

6.0 D37511 BLANKING PLATE

Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Shim B37486

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:53:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REMOVABLE HELI UTILITY STEP RH

Job Number: 37725

Part Number: D205541048

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

AN313A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt

M104746

AS 08/03/17 (X)

8.0

AN314A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt

M105953

AS 08/03/17 (X)

9.0

AN960JD10L

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)
Washer

M104885

AS 08/03/17 (X)

10.0

MS21042L3

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)
Nut

M106242

AS 08/03/17 (X)

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

APP: P/WC Kit on later date.

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-541-048

Location:

PPP Rev:

DRAFT 08/03/17 (X)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08-03-17 Kit: 08-03-17

POSITIVE RECALL

EFFECTIVE 08/03/17 AUTH

RELEASED 105 DATE 08.03.17

B 37974

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT

7.0 OPTIONAL EQUIPMENT

Qty -049	Part Number	Description
X	D205-541-049	LINER KIT
1	D2446	SIGN PLATE
1	D2509	LINER (BASE)
1	D2511	LINER (END)
6	MS24693S272	SCREW
6	A3235-020-935	WASHER
6	NAS679A3W	NUT
4	MS20470AD4-8	RIVET
42	MS20600AD4W4	RIVET

PRELIMINARY ISSUE
 ASS 08.03.11

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 37725

...CONTINUED FROM PREVIOUS PAGE

Qty -043	Qty -044	Qty -045	Qty -046	Part Number	Description
2*	2*			MS20600AD4W3	RIVET
2*	2*	2*	2*	MS21042L3	NUT (OR MS21042-3)
4*	4*	5*	5*	MS21042L4	NUT (OR MS21042-4)
16	16	16	16	MS21042L4	NUT (OR MS21042-4)
4*	4*	4*	4*	MS21042L5	NUT (OR MS21042-5)
2	2	2	2	MS21042L5	NUT (OR MS21042-5)

* = ASSEMBLED AT DART

6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

7.0 OPTIONAL EQUIPMENT

Qty -049	Part Number	Description
X	D205-541-049	LINER KIT
1	D2446	SIGN PLATE
1	D2509	LINER (BASE)
1	D2511	LINER (END)
6	MS24693S272	SCREW
6	A3235-020-935	WASHER
6	NAS679A3W	NUT
4	MS20470AD4-8	RIVET
42	MS20600AD4W4	RIVET

• COPYRIGHT © 1993 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: G

Date: 08.03.04